

Work Order ID 84929

May-29-12 2:56:42 PM

84929

Page 1

Item ID: D209-669-043

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Replacement Skidtube

Stop

NS2

Start Date: 29/05/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 16/07/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: MJ

Date: 12/05/29 Tooling:

Date:

Run Start

NR1

QC: _____

Date: _____ SPC (Y/N):

Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D2906	Rev B
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100 0.00

100

DOCUMENT CONTROL

DC

Document Control

Memo 0.00

Photocopy D209-669 bluefile & type labels per PPP D205-669-043 Chg 002

003
per 00125991 h

J/A DJ

110

110

Skidtubes

0.00

Skidtubes

Memo 0.00

Skidtubes

- Inspect mat'l D2500-1-190 for damage

- Drill pilot holes using drill jig DT8149, DT8711-2 & DT8711-3 (Do not use cutting fluid)

- Open holes to 0.500" as per Dwg D2906 without cutting fluid

- Deburr and blow out all chips from

- Acid etch and Alodine tube per QSI 005 4.1

SAD 12-06-20

① 26 12-6-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Required Date: 16/07/2012 **Req'd Qty:** 1.00

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Customer:

Reference:

Approvals:	Process Plan: _____	Date: _____	Tooling: _____	Date: _____	Run	Start	*NR1*
	QC: _____	Date: _____	SPC (Y/N): _____	Date: _____		Stop	*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							(1) SAD 12-07-04

130

130

Skidtubes

Skidtubes

Memo

0.00

(1)

SAD 11-07-04

Skidtubes

-Bond web in place per QSI 015. Allow 12 Hrs. cure time before cutting

Pick:

Qty Part Number Description Batch

A/R Sikaflex-291 3101409

Sikaflex expire date: 13-04-12

Start Time: 9:00 Date: 11-07-04

Fin Time: 1:30 Date: 12-07-05

pick:

Qty P/N description
1 D2926-3 Web

B/N
886263

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Cust Item ID:

Required Date: 16/07/2012 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	*NR1*
	QC:	Date:	SPC (Y/N):	Date:		Stop	*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 *140* CNC Bend 1	BENDING MACHINE - CROSSTUBES	0.00							
CNC Delta 100 Bender	Memo	0.00							
	1-Bend as per program COB43FWD & COBRAFT on CNC Bender and Folio FT								
	2-Cut tubes as per Dwg. D2906								
150 *150* Skidtubes	Skidtubes	0.00							
Skidtubes	Memo	0.00							
Skidtubes	-Deburr ends and remove marks from bending								
	- Insert D4202-1 spacer, swage as per QSI002 and trim/ grind flush per QSI002 and dwg. Hold x-bolt with DT9701 Use tube expander 1/2 x17G to start expansion and finish with 1/2 x 18G to achieve dwg dimension.								
160 *160* QC	QC5- Inspect part completeness to step on W/O	0.00							
Quality Control	Memo	0.00							

> De 12/07/05

> De 12/07/05

BB 12/07/05

1 0 86 12/07/05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Required Date: 16/07/2012 **Req'd Qty:** 1.00

1

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

170

170

Skidtubes

Operation
Description

Large Fab

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Skidtubes

Memo

0.00

-Drill holes for wearplates using DT8217 Open holes to 19/64", adjust stopper
not to hit web. Deburr

-Drill pilot holes for aft & fwd cap using DT8215 open holes to #6" Deburr

-Drill pilot holes for Tow ring using DT8091-3 , open to .640" and Deburr

①

SAD 2-07-05

190

190

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

5/21/05

Memo

0.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	*NR1*
	QC:	Date:	SPC (Y/N):	Date:		Stop	*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200 *200* HandFinish	Pressure Wash per QSI005 4.3	0.00							

200 HandFinish	Memo	0.00)	7/6	12-7-6
----------------------------	------	------	---	-----	--------

210 *210* Powdercoat	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00			
-----------------------------------	--	------	--	--	--

Powder Coating	Memo	10:00	0.00		
	START TIME:	10:00			
	OVEN TEMPERATURE:	320°F			
	FINISH TIME:	10:30			

220 *220* QC	QC3- Inspect Part Finish	0.00			
---------------------------	--------------------------	------	--	--	--

Quality Control	Memo	0.00			
-----------------	------	------	--	--	--

ML
1X 6 12/07/06

1X 6 ML 12/07/09

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Revision ID:

Item Name: Replacement Skidtube

Start Date: 29/05/2012 **Start Qty:** 1.00

1

Required Date: 16/07/2012 Req'd Qty: 1.00

本1

Reference:

Approvals: Process Plan:

Date:

Tooling:

Cust Item ID:

Customer:

Setup Start *NCS1*

Stop *ANSWER*

NS2

Stop

NR2

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Cust Item ID:

Required Date: 16/07/2012 **Req'd Qty:** 1.00 ***1***

Customer:

Reference:

Approvals:	Process Plan: _____	Date: _____	Tooling: _____	Date: _____	Run	Start	*NR1*
	QC: _____	Date: _____	SPC (Y/N): _____	Date: _____		Stop	*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240 *240* QC	QC5- Inspect part completeness to step on W/O	0.00	5.7410						
Quality Control	Memo Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024	0.00							
250 *250* Packaging Packaging	Packaging	0.00							12/11/12
	Memo Identify and pack for shipping as per PPPD209-669-043 Location: PPP Rev: <i>PPP 84890</i>	0.00							
260 *260* QC	QC21- Final Inspection - Work Order Release	0.00							12/11/12
Quality Control	Memo	0.00							

MF
12-07-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Page 1

Work Order ID: 84929

84929
D209-669-043

Parent Item: D209-669-043

Parent Item Name: Replacement Skidtube

Start Date: 29/05/2012

Required Date: 16/07/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: new IPP 08.02.13 LL, verified by: DD
IPP Rev:B remove DT # in seq140 DD 10.03.10 Verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4202-1		Manufactured	No				Each	81.0000	**	19		DC 12/07/05	
D4202-1 Spacer				<u>Location</u> B83263		<u>Loc Qty</u>		<u>Loc Code</u>		(19)			
				LG		5							
				77727		5							
				LG002		76							
				78806		6							
				79810		70							
D2500-1-190		Manufactured	No			110	Each	91.0000	1	1			
D2500-1-190 Ext'n - I' Beam Tube 4"				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>				SAD	12-08-21
				HALL		91							
				74777		14							
				8006		77							
D2926-3		Manufactured	No			110	Each	0.0000	1			(0)	
D2926-3 Web												SAD	12-07-08
D2855		Manufactured	No			230	Each	21.0000	2				
D2855 Cap				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				FP002		21		B84952				X2	
				65519		2							
				73347		16							
				75074		3							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 2

Work Order ID: 84929***84929***
D209-669-043**Parent Item:** D209-669-043**Parent Item Name:** Replacement Skidtube**Start Date:** 29/05/2012**Required Date:** 16/07/2012**Start Qty:** 1.00**Required Qty:** 1.00

AN3-5A

Purchased

No

230

Each

1,090.000

4

4

**

4112103109

AN3-5A

Bolt

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST350	1090	
115371	46	
117423	124	
118626	31	
119355	200	
120187	500	XJ
121185	189	

AN960JD10L

NAS1149D0332J Purchased

No

230

Each

0.0000

4

4

M1121011

**

(XJ) 4112103109

***AN960.JD10L ***

Washer

ALS7-1032-130

Purchased

No

230

Each

2,136.000

44

44

**

(XJ) 4112103109

ALS7-1032-130

Insert

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST280	51	
117717	27	
118966	22	
119775	2	
ST282	2085	
119530	73	
120181	12	
121444	2000	

W/O:		WORK ORDER CHANGES					
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Work Order ID: 84929

84929
D209-669-043

Parent Item: D209-669-043

Parent Item Name: Replacement Skidtube

Start Date: 29/05/2012

Required Date: 16/07/2012

Start Qty: 1.00

Required Qty: 1.00

AN3C4A

Purchased

No

230

Each

1,458.000

44

44

**

Al 1207109

AN3C4A

BOLT

Location	Loc Qty	Loc Code
ST350	1458	11122151
120187	57	
120521	28	
120769	38	
121205	1000	
121556	335	

AN960C10L

NAS1149C0332
R

Purchased

No

230

Each

0.0000

44

44

11122063

**

(x44) Al 1207109

*AN960C10I *

washer

D2594-3

Manufactured

No

230

Each

2,418.000

14

14

**

Al 1207109

D2594-3

O-Ring, 205 Skidtube

Location	Loc Qty	Loc Code
FP001	2418	
65518	41	
79496	984	
79573	50	
79755	1343	X14

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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Parent Item Name: Replacement Skidtube

Start Date: 29/05/2012

Required Date: 16/07/2012

Start Qty: 1.00

Required Qty: 1.00

D2594-1

Manufactured No

230

Each

311.0000

14

14

**

*SL 1107109****D2594-1***

Plug, 205 Skidtube

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP001	98	
73401	30	
74442	18	
79495	50	
FP-A	213	
73401	0	
<u>78590</u>	213	

D3564-9

Manufactured No

230

Each

22.0000

1

1

**

*SL 1207109****D3564-9***

Wearshoe

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FG	4	<u>1384870</u>
76950	4	
FP001	18	
67590	4	
69943	1	
82255	13	

D3564-11

Manufactured No

230

Each

8.0000

1

1

**

*SL 1107108****D3564-11***

Wearshoe

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FG	4	<u>1384871</u>
77056	4	
FP001	4	
80341	4	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Parent Item Name: Replacement Skidtube

Start Date: 29/05/2012

Required Date: 16/07/2012

Start Qty: 1.00

Required Qty: 1.00

D3564-5

Manufactured No

230

Each

13 0000

1

1

**

SL 1104109

D3564-5

Wearshoe

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FG	2	B85475
34806	2	XL
FP001	11	
77609	3	
82254	8	

D3566-1

Manufactured No

230

Each

31.0000

2

2

**

SL 1104109

D3566-1

Gasket

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP	-22	B84879
81619	10	VZ
FP002	53	
68924	2	
80919	3	
83898	16	

D3566-5

Manufactured No

230

Each

21.0000

1

1

**

SL 1104109

D3566-5

Gasket

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP	12	
82275	12	Y1
FP002	9	
80374	3	
82274	6	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

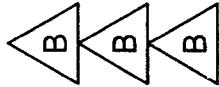
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QTY	QTY	Part Number	Description
-041	-043	D2906-041	SKIDTUBE ASSEMBLY
X	X	D2906-043	SKIDTUBE ASSEMBLY
1	1	D2500-1-190	EXTRUSION
22	19	D2579	CROSS BOLT SPACER
12	14	D2594-1	PLUG
12	14	D2594-3	O-RING
2	2	D2855	AFT CAP
1	1	D2926-1	WEB
1	1	D2926-3	WEB
1	1	D3564-9	WEARSHOE (REPLACES D2577-1)
1	1	D3564-11	WEARSHOE (REPLACES D2577-3)
1	1	D3564-5	WEARSHOE (REPLACES D2577-5)
1	1	D3564-15	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
1	1	D3566-15	GASKET
50	44	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or ALS4-1032-130	INSERT
50	44	AN3C4A	BOLT
4	4	AN3C5A	BOLT
50	44	AN960C10L	WASHER
4	4	AN960D10L	WASHER



GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 2) LENGTH OF D2500-1 EXTRUSION BEFORE BENDING = 190 INCHES.
- 3) INSERT D2926-1/-3 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX 241/291 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 6) USE DART DRILL TEMPLATE DT2906-041T1 (D2906-041) OR DT2906-043T1 (D2906-043) TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION C-C AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/291.
- 7) WELDING TO BE DONE PER DART QSI 004.
- 8) FINISH:
ACID ETCH, ALODINE PER DART QSI 005.4.1 PRIOR TO INSERTING D2926-1/-3 WEB. POWDER COAT ASSEMBLY WHITE (REF 4.3.5.1) PER DART QSI 005.4.3 BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005.4.4
- 9) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (12 PLACES).
- 10) ALL DIMENSIONS ARE IN INCHES.

RELEASED

07.04.04

REV.	DESIGN DRAWN	BY CB	DATE 07.08.21
B	PG 2 C7: REMOVE AFT Ø0.640 HOLE FROM -041; PG 3 C3: CORRECTED -043 CAP P/N; PG 3 D7: 38 PLACES WAS 44 PLACES;	DRAWING NO. 	REV. B SHEET 1 OF 3
A	NEW ISSUE	CP	04.06.22
			SCALE NTS
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DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

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WITHOUT NOTICE
WORK ORDER
NO. 84929 MCJ
12/05/29

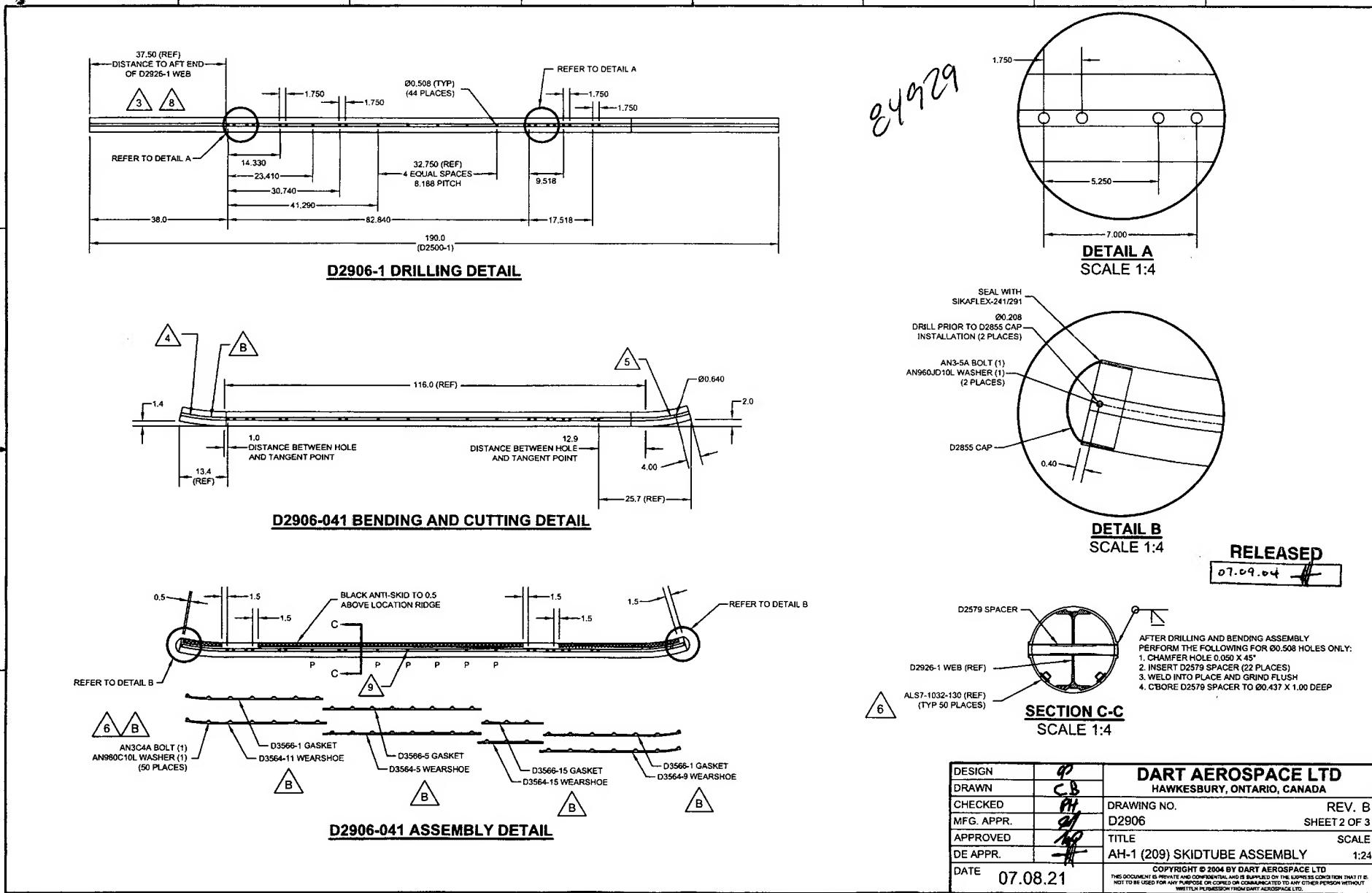
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	P	DART AEROSPACE LTD
DRAWN	CB	HAWKESBURY, ONTARIO, CANADA
CHECKED	PH	DRAWING NO.
MFG. APPR.	SJ	REV. B
APPROVED	AS	D2906
DE APPR.	AS	SHEET 2 OF 3
DATE 07.08.21		TITLE AH-1 (209) SKIDTUBE ASSEMBLY
		SCALE 1:24
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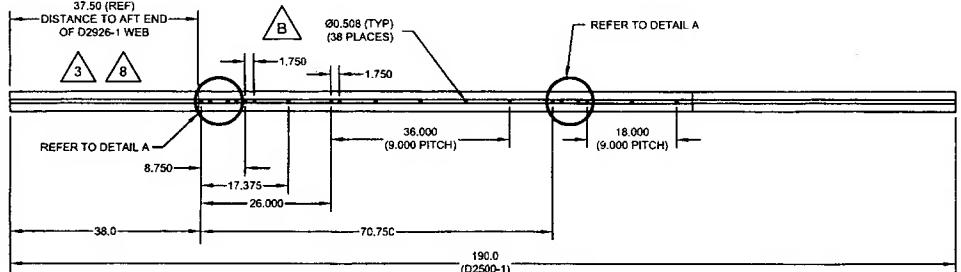
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

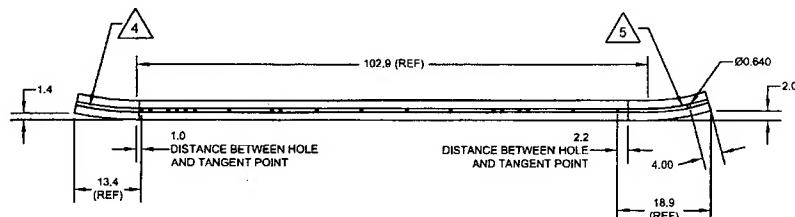
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

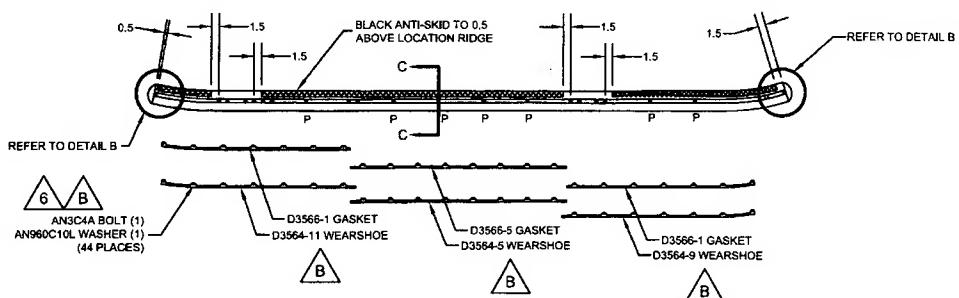
NOTE: Date & initial all entries



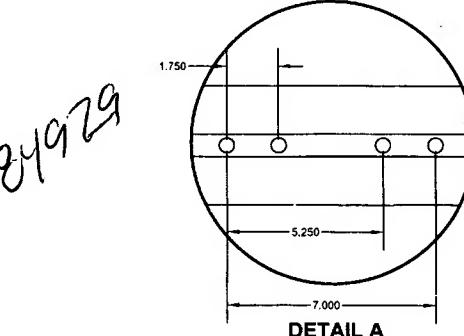
D2906-3 DRILLING DETAIL



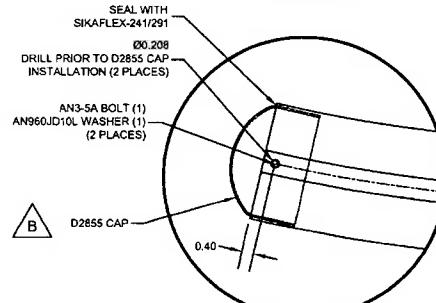
D2906-043 BENDING AND CUTTING DETAIL



D2906-043 ASSEMBLY DETAIL

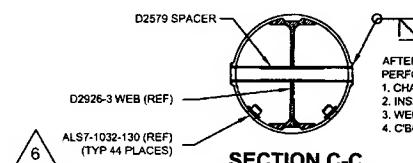


DETAIL A
SCALE 1:4



DETAIL B
SCALE 1:4

RELEASED



SECTION C-C

DESIGN	<i>9</i>	DART AEROSPACE LTD		
DRAWN	<i>C8</i>	HAWKESBURY, ONTARIO, CANADA		
CHECKED	<i>PH</i>	DRAWING NO.	REV. B	
MFG. APPR.	<i>SJ</i>	D2906	SHEET 3 OF 3	
APPROVED	<i>HC</i>	TITLE	SCALE	
DE APPR.	<i>HC</i>	AH-1 (209) SKIDTUBE ASSEMBLY	1:24	
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W/O:

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng/ Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries